

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

| | | | | | | | | | | | | |
|--|--|------|------|--|---|--|-------------------|---|--|---|--------------|--------------|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Rework _____ Scrap _____ Use-as-is _____ Suspected Unapproved _____ | | | | Skid-tube _____ Machining _____ Thermoforming _____ Large Fab _____ | | Crosstube _____ Small Fab _____ Finishing _____ Composite _____ | | Water Jet _____ Prod. Eng. Coor. _____ Rec/Store/Packaging _____ Supplier _____ | | Engineering _____ Quality _____ Other _____ | | |
| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <ul style="list-style-type: none"> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <ul style="list-style-type: none"> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | | | | <ul style="list-style-type: none"> <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <ul style="list-style-type: none"> <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <ul style="list-style-type: none"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | |

Work Order ID 122299

Monday, July 14, 2014 1:55:24 PM

122299

Page 2

Item ID: D3641-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover

Stop

NS2

Start Date: 7/14/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-------------------|-------------------|---------------|---------------|------------------|----------------|
| 130 *130* Brake NC | NC BRAKE Memo Form as per Dwg D3641-1 | 0.00 | | DAS 30 9-89 | | 9 | | | 14/09/09 |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | DAS 38 9-89 | 9 | | | 14-9-8 |
| 150 *150* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 9 | 7/14/9-10 | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

| | | | | | | | | | |
|-------------------|----------------------|-------|-----------|----------------------------|-----------|---------------------|-------------|--|--|
| Work Order: _____ | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework | Scrap | Use-as-is | Skid-tube | Crosstube | Water Jet | Engineering | | |
| NCR No. _____ | Suspected Unapproved | | | Machining | Small Fab | Prod. Eng. Coor. | Quality | | |
| | | | | Thermoforming | Finishing | Rec/Store/Packaging | Other | | |
| | | | | Large Fab | Composite | Supplier | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | | | | | | | |
|--------------------------|--|----------------------|--|-----------------------------------|--|----------------------|--|--------------------|--|--|--|
| Landing Gear | | General | | | | | | | | | |
| Bending | | Bend | | Folio/Program | | Outside Dimensions | | Pressure/Forced | | | |
| Centre Not Concentric | | BOM/Route | | Grain | | Over/Under tolerance | | Set-up | | | |
| Cracks | | Broken/Damage/Defect | | Hardware | | Part Incorrect | | Temperature/Cure | | | |
| Crimp/Kink/Ripple/Wave | | Burrs | | Inspection Incomplete/Unqualified | | Part Lost/Missing | | Weld | | | |
| Cuffs | | Contamination | | Instructions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled | | | |
| Crushing | | Countersink | | Misaligned/off center | | Positioned Wrong | | | | | |
| Heat Treat | | Cut Too Short | | Mislabeled | | Power Loss/Surge | | | | | |
| Inspection Strip in Tube | | Drawing | | Misread | | | | | | | |
| Marks/Chatter | | Drill Holes | | Off-set | | | | | | | |
| Turning Sequence | | Finish | | Out of Calibration | | | | | | | |
| Wave/Twist in Tube | | Fit/Function | | Out of Sequence | | | | | | | |

Work Order ID 122299

Monday, July 14, 2014 1:55:24 PM

122299

Page 3

Item ID: D3641-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover

Stop

NS2

Start Date: 7/14/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

9

8

00

17/09/11

Quality Control

170

Identify as per dwg & Stock Location: ST466 0.00

170

Packaging

Packaging

Memo

0.00

9x

DAS
28
0.00

SEP 11 2014

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

0.00

14/9/12 JJ

UMF
14-9-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

| | | | | | | | | |
|-------------------|-------------|------------|-----------|----------------------------|-----------|---------------------|-------------|--|
| Work Order: _____ | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | |
| Part No. _____ | Rework | Scrap | Use-as-is | Skid-tube | Crosstube | Water Jet | Engineering | |
| NCR No. _____ | Suspected | Unapproved | | Machining | Small Fab | Prod. Eng. Coor. | Quality | |
| | | | | Thermoforming | Finishing | Rec/Store/Packaging | Other | |
| | | | | Large Fab | Composite | Supplier | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | 20 | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | | | | | | | |
|---|---|--|--|--|--|--|---|--|---|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | | | <input type="checkbox"/> Folio/Program | | | <input type="checkbox"/> Outside Dimensions | | <input type="checkbox"/> Pressure/Forced |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | | | <input type="checkbox"/> Grain | | | <input type="checkbox"/> Over/Under tolerance | | <input type="checkbox"/> Set-up |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | | | <input type="checkbox"/> Hardware | | | <input type="checkbox"/> Part Incorrect | | <input type="checkbox"/> Temperature/Cure |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | | | <input type="checkbox"/> Inspection Incomplete/Unqualified | | | <input type="checkbox"/> Part Lost/Missing | | <input type="checkbox"/> Weld |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | | | <input type="checkbox"/> Instructions Incomplete/Unclear | | | <input type="checkbox"/> Part Moved | | <input type="checkbox"/> Wrong Stock Pulled |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | | | <input type="checkbox"/> Misaligned/off center | | | <input type="checkbox"/> Positioned Wrong | | |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | | | <input type="checkbox"/> Mislabeled | | | <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Other |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | | | <input type="checkbox"/> Misread | | | | | |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | | | <input type="checkbox"/> Off-set | | | | | |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | | | <input type="checkbox"/> Out of Calibration | | | | | |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | | | <input type="checkbox"/> Out of Sequence | | | | | |

Picklist Print

Monday, July 14, 2014 1:55:23 PM

Page 1

Work Order ID: 122299

122299

Parent Item: D3641-1

D3641-1

Parent Item Name: Cover

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|------------|
| M5052H32S.032 | | Purchased | No | | | 100 | sf | 181.8000 | 0.7987 | 6725894 | | | 23 9-89 |

M5052H32S 032

5052-H32 .032 Sheet

| Location | Loc Oty | Loc Code |
|----------|---------|----------|
| MAT022 | 181.8 | |
| 116657 | 22 | |
| 117798 | 3 | |
| 121040 | 3 | |
| m126593 | 153.8 | 126593 |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

| | | | | | | | | | | |
|-------------------|----------------------|--------------------------|---------------|----------------------------|-----------|--------------------------|---------------------|--------------------------|-------------|--------------------------|
| Work Order: _____ | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Part No. _____ | Rework | <input type="checkbox"/> | Skid-tube | <input type="checkbox"/> | Crosstube | <input type="checkbox"/> | Water Jet | <input type="checkbox"/> | Engineering | <input type="checkbox"/> |
| NCR No. _____ | Scrap | <input type="checkbox"/> | Machining | <input type="checkbox"/> | Small Fab | <input type="checkbox"/> | Prod. Eng. Coor. | <input type="checkbox"/> | Quality | <input type="checkbox"/> |
| | Use-as-is | <input type="checkbox"/> | Thermoforming | <input type="checkbox"/> | Finishing | <input type="checkbox"/> | Rec/Store/Packaging | <input type="checkbox"/> | Other | <input type="checkbox"/> |
| | Suspected Unapproved | <input type="checkbox"/> | Large Fab | <input type="checkbox"/> | Composite | <input type="checkbox"/> | Supplier | <input type="checkbox"/> | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | |
|--------------|--------------------------|--------------------------|--------------------------|-----------------------------------|--------------------------|
| Landing Gear | General | | | | |
| | <input type="checkbox"/> | Bending | <input type="checkbox"/> | Folio/Program | <input type="checkbox"/> |
| | <input type="checkbox"/> | Centre Not Concentric | <input type="checkbox"/> | Grain | <input type="checkbox"/> |
| | <input type="checkbox"/> | Cracks | <input type="checkbox"/> | Hardware | <input type="checkbox"/> |
| | <input type="checkbox"/> | Crimp/Kink/Ripple/Wave | <input type="checkbox"/> | Inspection Incomplete/Unqualified | <input type="checkbox"/> |
| | <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> |
| | <input type="checkbox"/> | Crushing | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> |
| | <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> |
| | <input type="checkbox"/> | Inspection Strip in Tube | <input type="checkbox"/> | Misread | <input type="checkbox"/> |
| | <input type="checkbox"/> | Marks/Chatter | <input type="checkbox"/> | Off-set | <input type="checkbox"/> |
| | <input type="checkbox"/> | Turning Sequence | <input type="checkbox"/> | Out of Calibration | <input type="checkbox"/> |
| | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> |
| | <input type="checkbox"/> | | <input type="checkbox"/> | | <input type="checkbox"/> |
| | <input type="checkbox"/> | | <input type="checkbox"/> | | <input type="checkbox"/> |
| | <input type="checkbox"/> | | <input type="checkbox"/> | | <input type="checkbox"/> |

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | <u>127299</u> |
| Description: Cover | Part Number: | <u>D3641-1</u> |
| Inspection Dwg: D3641 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

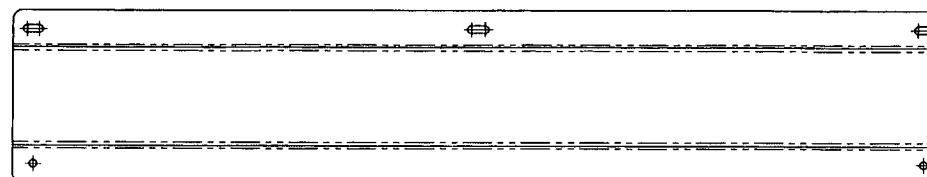
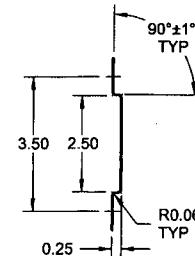
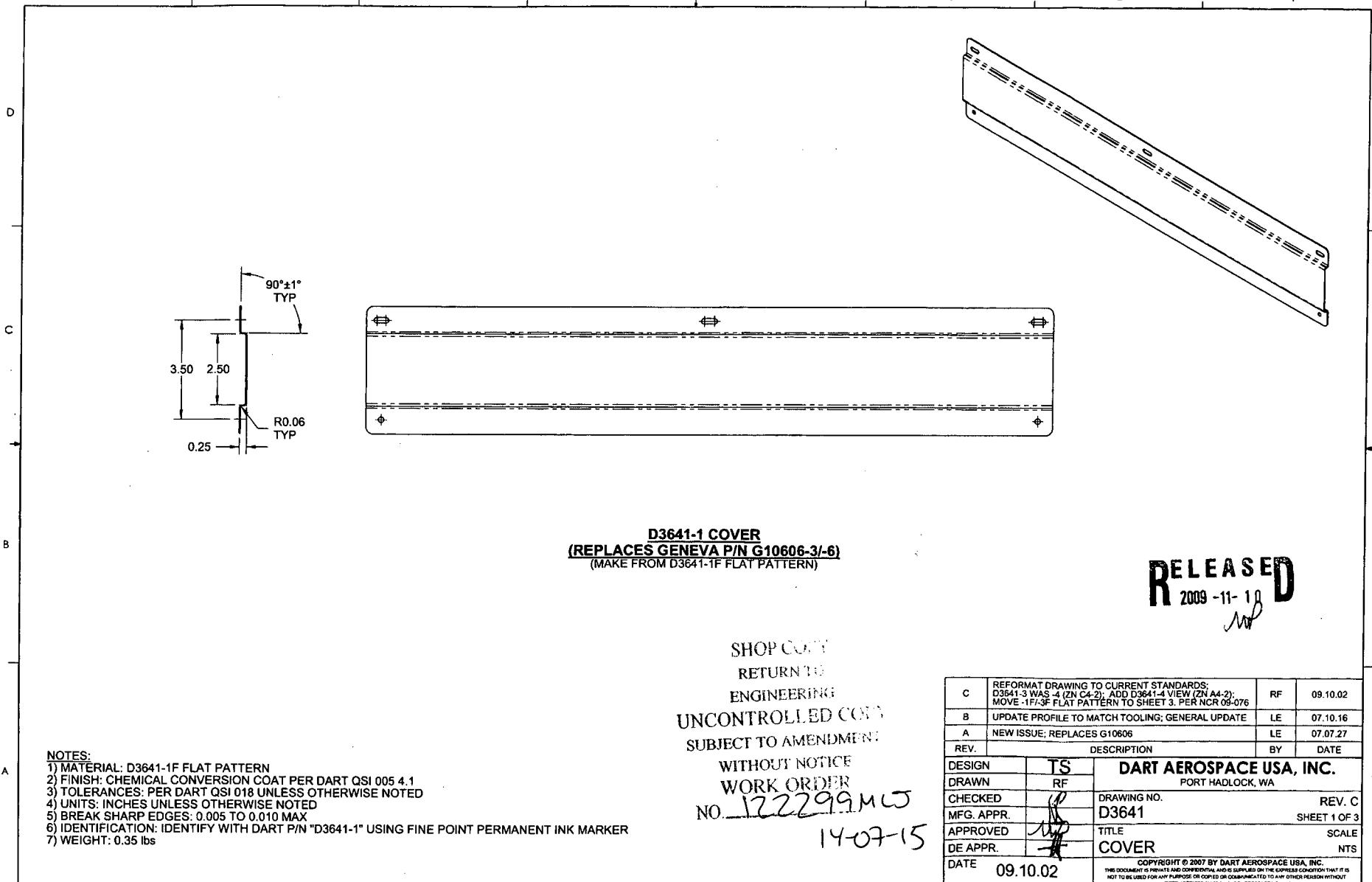
1145

—DAS

| | | | | | |
|--------------|------------|-------------|------------|-----------------------|--|
| Measured by: | 23 9-89 | Audited by: | 38 9-89 | Preliminary Approval: | |
| Date: | 14-09-4 | Date: | 14-9-4 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 09.09.15 | New Issue | KJ | |
| B | 12.03.08 | Dwg Rev updated | KJ | |

8 7 6 5 4 3 2 1



D3641-1 COVER
(REPLACES GENEVA PIN G10606-3/-6)
(MAKE FROM D3641-1F FLAT PATTERN)

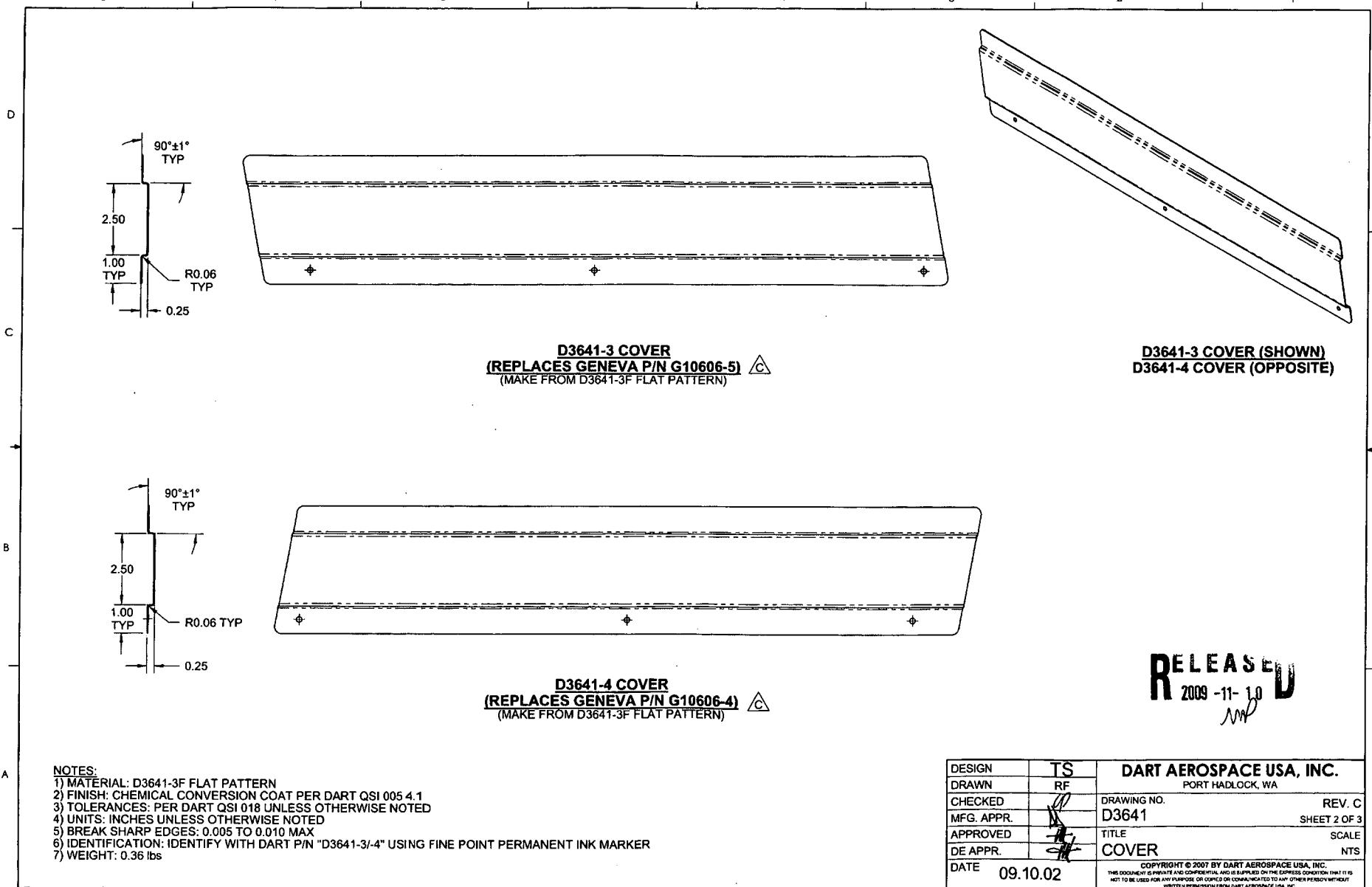
NOTES:
1) MATERIAL: D3641-1F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.35 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 172299M 15
14-07-15

| | | | |
|------------|---|--|--------------|
| C | REFORMAT DRAWING TO CURRENT STANDARDS: D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076 | RF | 09.10.02 |
| B | UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE | LE | 07.10.16 |
| A | NEW ISSUE; REPLACES G10606 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | TS | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | <u>RP</u> | DRAWING NO. | REV. C |
| MFG. APPR. | | D3641 | SHEET 1 OF 3 |
| APPROVED | <u>MJ</u> | TITLE | SCALE |
| DE APPR. | <u>RP</u> | COVER | NTS |
| DATE | 09.10.02 | COPRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

8 7 6 5 4 3 2 1



| DESIGN | TS | DART AEROSPACE USA, INC. |
|------------|----------|--------------------------|
| DRAWN | RF | PORT HADLOCK, WA |
| CHECKED | | DRAWING NO. |
| MFG. APPR. | | D3641 |
| APPROVED | | REV. C |
| DE APPR. | | SHEET 2 OF 3 |
| DATE | 09.10.02 | TITLE |
| | | COVER |
| | | SCALE |
| | | NTS |

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
2009-11-10

8 7 6 5 4 3 2 1

